

(19)



JAPANESE PATENT OFFICE

PATENT ABSTRACTS OF JAPAN

(11) Publication number: **59056958 A**(43) Date of publication of application: **02.04.84**

(51) Int. Cl.

B22D 17/00**B22D 17/32**(21) Application number: **57168214**(22) Date of filing: **27.09.82**(71) Applicant: **NISSIN KOGYO KK**(72) Inventor:
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(57) Abstract:

PURPOSE: To prevent the generation of blowholes by sucking beforehand the air from a cavity by a vacuum device and pressing a molten metal in this state by a punch thereby packing the molten metal into the cavity.

CONSTITUTION: A titled device is constituted of the cavity 2 in a die 1, a vacuum pump 24 which sucks the air from the inside thereof, a solenoid valve 22 which controls the volume of the air to be sucked by the vacuum pump between the cavity 2 and the pump 24, a punch 17 which presses and packs a molten metal into the cavity 2, the 1st switch 18 which detects the point of the time when the pressing of the molten metal by the punch 17 is started, the 2nd switch 19 which detects the point of the time just before the pressing of the molten metal by the punch 17 ends, and a control unit 20 which opens the valve 22 in accordance with the signal from the 1st switch 18 outputted at the point of the time when the pressing of the molten metal is started and closes the valve 22 in accordance with the signal from the 2nd switch 19 outputted at the point of the time just before the pressing of the molten metal ends.

